

Work Order ID 100698

April-30-13 8:08:53 AM

\*100698\*

Page 1

Item ID: D4585-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Door Assembly, Half Vertical Reference Window, LH

Start Date: 4/30/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/07/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11-04-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4585	C								
100	Pick Kit	0.00							
<b>*100*</b>									
Packaging	Memo	0.00							
Packaging									
110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D4585 Dwg. Rev. <u>C</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

RD4792

Dh  
13/04/20Dh  
13/04/20  
PTO →  
LAST PAGE

Work Order ID 100698

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\*100698\*

Order ID 100698 Page 2

Item ID: D4585-041

Accept

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Setup Start \*NS1\*

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Stop \*NS2\*

Start Date: 4/30/13 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/07/13 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
*130*									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
*140*									
QC	Memo	0.00							
Quality Control									

USED FOR  
FLIGHT TEST

U130506

# Picklist Print

April-30-13 8:08:57 AM

Page 1

Work Order ID: 100698

\*100698\*

Parent Item: D4585-041

\*D4585-041\*

Parent Item Name: Door Assembly, Half Vertical Reference Window, LH

Start Date: 4/30/13

Required Date: 5/07/13

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev. A New Issue 12/02/21 DL  
12.10.12 as per dwg rev.b DD VERF:JLM  
AS PER REV.C DD verf:JLM

IPP REV:B  
IPP REV:C 12.12.05

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3802-1-135 *D3802-1-135* Window Seal		Manufactured	No			100	Each	2.0000	1	1			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST408 81868.			2		135 inches.			
					87573			2					
D4465-041 *D4465-041* Medium Bell Door Assembly, LH		Manufactured	No			100	Each	0.0000	1	1			
									**				
D4504-1 *D4504-1* Half Height Bubble Window, LH		Manufactured	No			100	Each	0.0000	1	1			
									**				
AN3-6A *AN3-6A* Bolt		Purchased	No			100	Each	432.0000	28	28			
									**				
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST350			300					
					124296			300					
					ST351			61					
					117441			34					
					121166			13					
					122993			10					
					123831			4					
					ST512			71					
					122814			71		22			

Oh.  
13/04/29

Oh.  
13/04/29

Oh.  
13/04/29

# Picklist Print

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Work Order ID: 100698

Parent Item: D4585-041

Parent Item Name: Door Assembly, Half Vertical Reference Window, LH

\*100698\*

\*D4585-041\*

Start Date: 4/30/13

Required Date: 5/07/13

Start Qty: 1.00

Required Qty: 1.00

AN3-16A

Purchased

No

100

Each

90.0000

1

1

~~\*AN3-16A\*~~

Bolt

\*\*

AN3-7A. *ole*

Location

Loc Qty

Loc Code

GA

47

117441

47

ST352

127805

43

~~122407~~

8

123900

35

(4)

*OK*  
13/04/29

MS21042L3

Purchased

No

100

Each

4,504.000

1

1

~~\*MS21042L3\*~~

Nut

\*\*

MS21042-3

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

75

122452

75

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

4158

123900

974

124291

3184

123352

(22)

*OK*  
13/04/29

# Picklist Print

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Page 3

Work Order ID: 100698

\*100698\*

Parent Item: D4585-041

\*D4585-041\*

Parent Item Name: Door Assembly, Half Vertical Reference Window, LH

Start Date: 4/30/13

Required Date: 5/07/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

100

Each

1,566.000

30

30

**\*NAS1149D0332.I\***

\*\*

Washer

## Location

## Loc Qty

## Loc Code

ST293

963

125268

963

ST294

603

122973

68

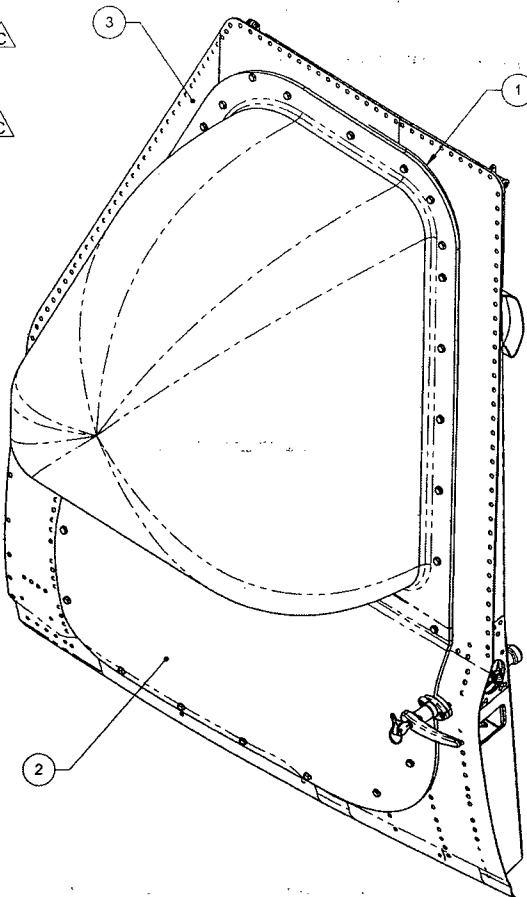
125044

535

48

OK  
13/04/29

ITEM	QTY	P/N	DESCRIPTION
	X	D4585-041	DOOR ASSY HALF VERT REF WINDOW
1	1	D3802-1-135	SEAL
2	1	D4504-1	HALF HEIGHT BUBBLE WINDOW
3	1	D4465-041	MED BELL DOOR ASSY (LH)
4	28	AN3-6A	BOLT
5	1	AN3-16A	BOLT
6	1	MS21042L3	NUT
7	30	NAS1149D0332J	WASHER



SHIRLEY  
R. J. J. J.  
ENGINEER, G  
UNCONTROLLED COPY  
SUBJECT TO REDESIGN  
WITHOUT NOTICE  
WORK ORDER  
NO. 100698 MWS  
1304-30

RELEASED  
2012-11-29  
MP

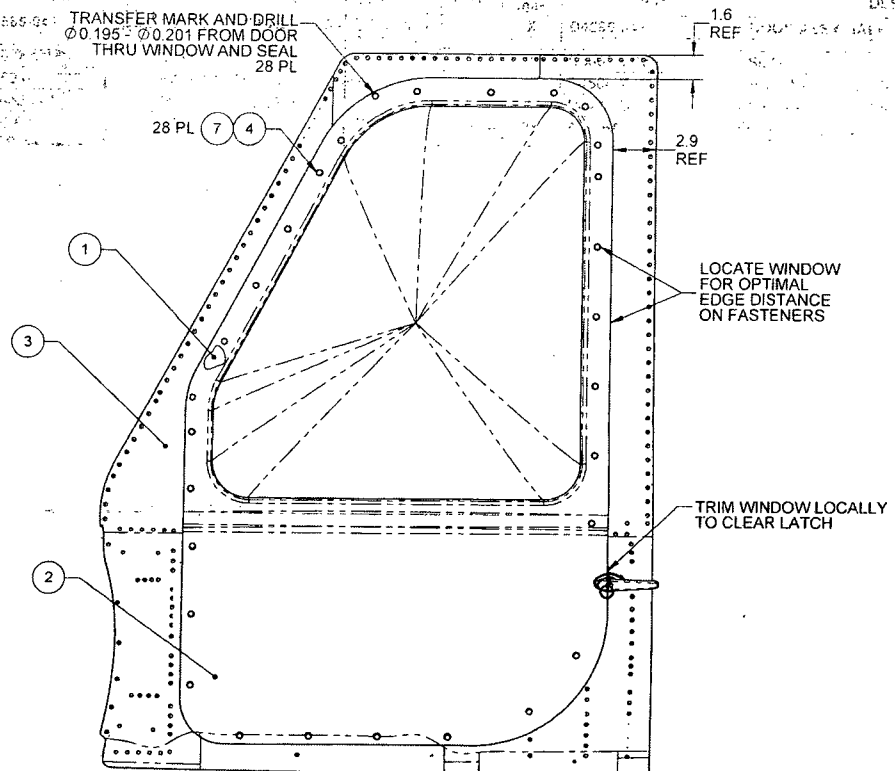
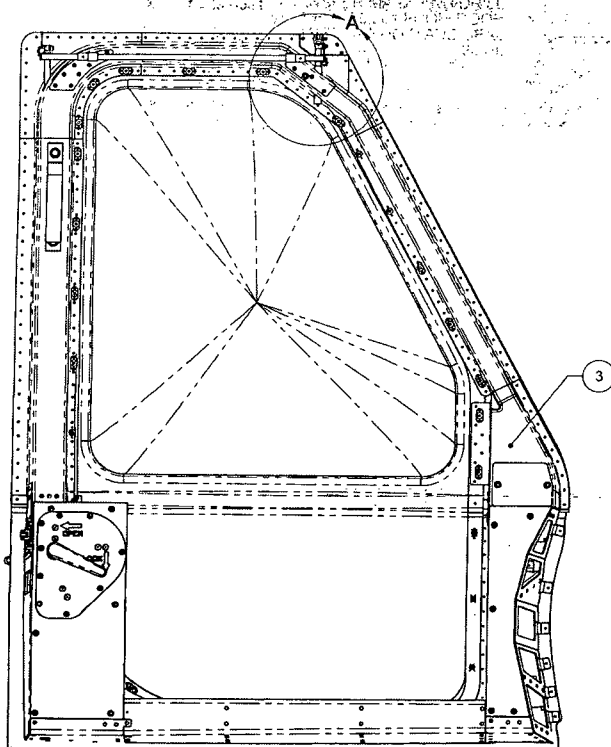
## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 29.2 LBS ESTIMATED

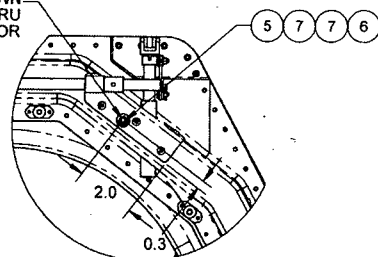
**D4585-041 DOOR ASSY, HALF VERT REF WINDOW (LH)**

C	ADDED -042 (RH CONFIGURATION). 1 WINDOW FASTENER DELETED.	AJS	12.10.16
B	VIEWS UPDATED FOR REDESIGNED DOOR STRUCTURE.	AJS	12.09.11
A	NEW ISSUE	AJS	12.02.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	DS	D4585	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	DOOR ASSY, HALF VERT REF WINDOW	NTS
DATE	12.10.16	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONVEYED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

100698



LOCATE APPROX AS SHOWN  
DRILL Ø0.195 - Ø0.201 THRU  
STRUCTURE WINDOW AND DOOR



**DETAIL A**  
SCALE 2X

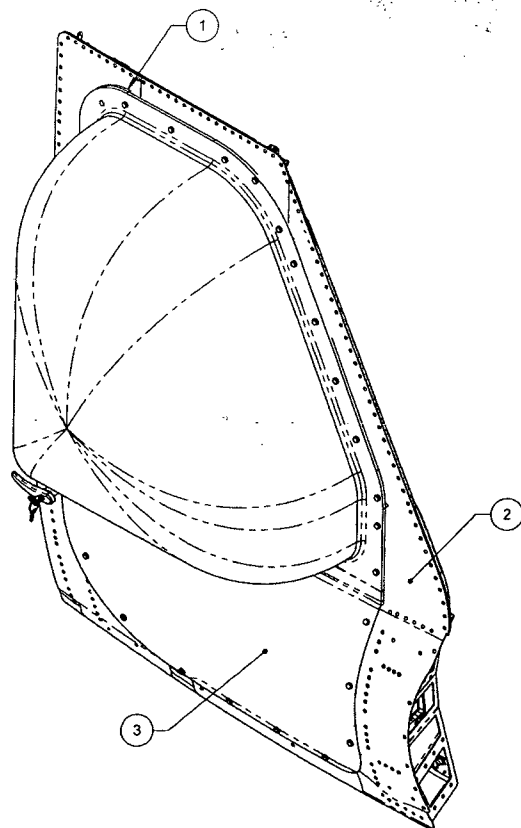
**D4585-041 DOOR ASSY, HALF VERT REF WINDOW (LH)**

RELEASED  
2012-11-29  
MP

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	<b>D4585</b>	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR ASSY, HALF VERT REF WINDOW	NTS
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100692

ITEM	QTY	P/N	DESCRIPTION
	X	D4585-042	DOOR ASSY HALF VERT REF WINDOW (RH)
1	1	D3802-1-135	WINDOW SEAL
2	1	D4465-042	MED BELL DOOR ASSY (RH)
3	1	D4504-2	HALF HEIGHT BUBBLE WINDOW
4	28	AN3-6A	BOLT
5	1	AN3-16A	BOLT
6	1	MS21042L3	NUT
7	30	NAS1149D0332J	WASHER



**D4585-042 DOOR ASSY, HALF VERT REF WINDOW (RH)**

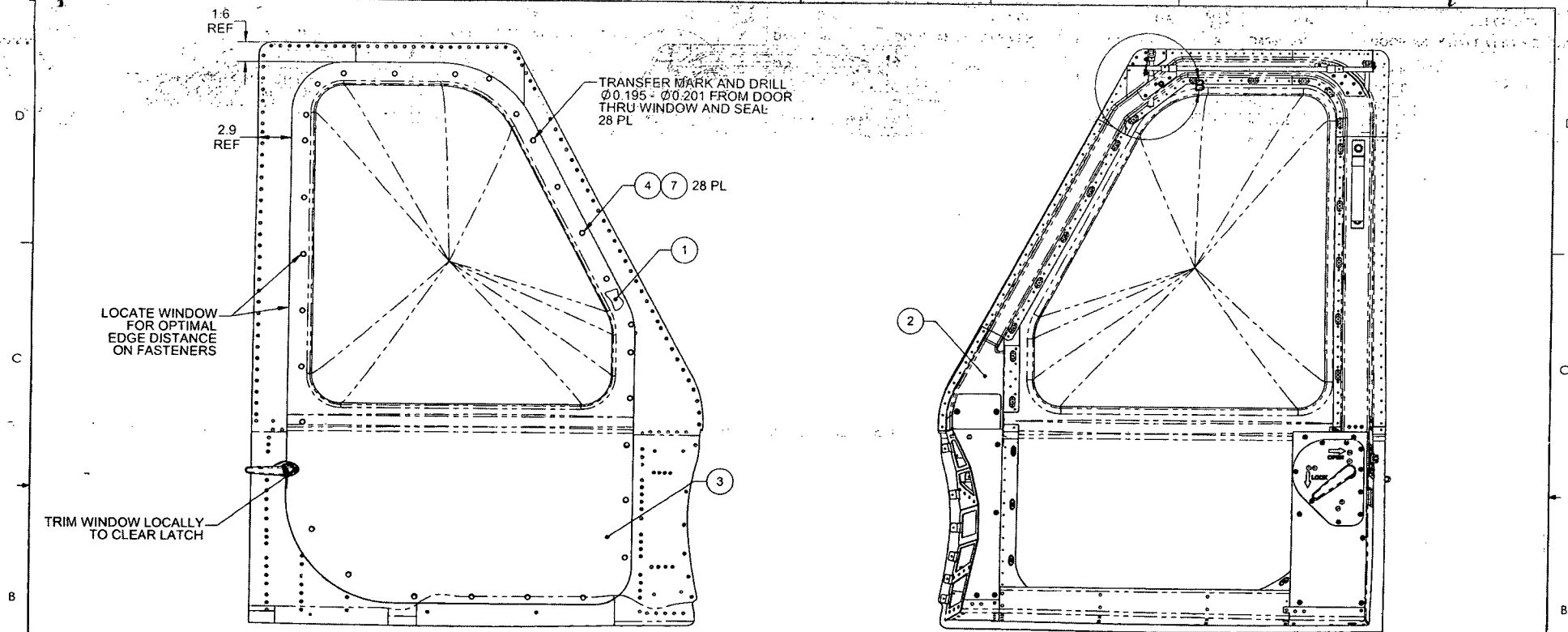
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 29.2 LBS ESTIMATED

RELEASED  
2012-11-29  
MP

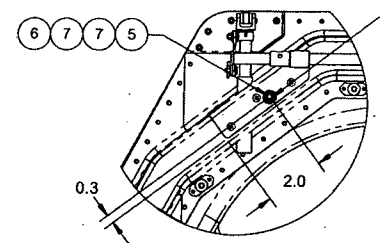
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4585	SHEET 3 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	DOOR ASSY, HALF VERT REF WINDOW	NTS
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100698



**D4585-042 DOOR ASSY, HALF VERT REF WINDOW (RH)**




LOCATE APPROX AS SHOWN  
DRILL  $\varnothing 0.195 - \varnothing 0.201$  THRU  
STRUCTURE WINDOW AND DOOR

RELEASED  
2012-11-29  
MJP

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4585</b>	REV. C
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOOR ASSY, HALF VERT REF WINDOW	
DATE	12.10.16	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
13/04/2013	110	Substitute. 4x AN3-7A BOLTS. For 4x AN3-6A BOLTS. 22x MS21042-3 NUTS. For 22x MS21042-3 NUTS.	She	13/04/2013	4 22	 2013/04/30	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries